

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002570**Date Inspected:** 11-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang SAi Fa and Lvliqing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG & SAS Tower Fabrication**Summary of Items Observed:**

On this date, Caltrans Office of Structural Material (OSM) Quality Assurance (QA) Inspector Joselito Lizardo was present as requested to perform observations on the fabrication of Orthotropic Box Girder (OBG) and SAS Tower at Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China.

This QA Inspector was given a walk through on Bays 2, 3, 4, 7 & 8 by QA Sherri Brannon as part of training and orientation in this ZPMC Facility. The following observations were noted;

- 1) Bay 2: Thermal cutting, rolling and beveling of various tower plates diaphragm were on going.
- 2) Bay 3: This QA Inspector observed ZPMC personnel performing various tasks relative to the fabrication of side, bottom and edge panels for Orthotropic Box Girders.
- 3) Bay 4: This QA Inspector observed ZPMC personnel performing Complete Joint Penetration (CJP) & Partial Joint Penetration (PJP) Submerged Arc Welding on plate splices intended for Tower Diaphragm. Thermal heat straightening using oxy-acetylene was also observed on various side, bottom and edge panels. Quality Control Inspector was observed monitoring the temperature with calibrated heat gun.
- 4) Bay 7: Caltrans QA has observed numerous floor beams sub-assemblies in different stages of fabrication ranging from tacking/fit-up, welding and inspection. Items that are done here are all intended for OBG Floor beams.
- 5) Bay 8: Caltrans QA has observed Submerged Arc Welding on plate splices intended for Tower Diaphragm.

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Summary of Conversations:

For more details on the above observations, please refer to Sherri Brannon's report on this day.

This QA and the rest of the QA's who worked this day were scheduled to leave job site at 1500. For unknown reason there was no available ferry to bring us back to the Hotel so we stayed at job site till 1700.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Lizardo, Joselito	Quality Assurance Inspector
Reviewed By:	Cochran, Jim	QA Reviewer
